

Date: Monday, 9/10/2007 1:19:06 PM  
 User: Kim Johnston

## Process Sheet

Split 1

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM
Job Number	: 34477			
Estimate Number	: 12884			
P.O. Number	: N/A		Part Number	: D3560044
This Issue	: 9/10/2007	S.O. No. : N/A	Drawing Number	: D3560 UNDER REVIEW
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A		Drawing Revision	: P/C
Previous Run	: 32648		Material	: N/A
Written By			Due Date	: 9/17/2007
Checked & Approved By			Qty:	12 Um: Each
Comment	: Est Rev:A New Issue 07.05.24 EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"	
		Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s) 6061-T6 Bar 0.50" x 5.0" Batch: M1051646	
			7NL 07/09/20 (12)
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks 15.500" long	
			7NL 07/09/20 (12)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA696 Rev: K & Dwg D3560 Rev: L	
		2-C'sink 0.196" hole on manual mill as per dwg D3560	
		3-Deburr per dwg D3560	
			8F 07/09/22
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
			8F 07/09/22
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
			J.F. 07/09/23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-11	1	Scrap 2 arms because of crack will replace with new arm & plate						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

334260 (4) 334478 (1) 12 07.10.10 5

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1

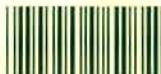


Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 07.10.11

(6)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

w/f 07/10/11

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

a.m

07.10.12

(5)

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/10/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01.10.11	1	scrapped two <del>assemblies</del> assemblies had to replace (cause of cracked) 01/10/11	<input checked="" type="checkbox"/>	welded two more assemblies	<input checked="" type="checkbox"/> 01.10.11	<input checked="" type="checkbox"/> 01/10/11	<input checked="" type="checkbox"/> 01/10/11	<input checked="" type="checkbox"/> 01/10/11

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/15

Job Completion:



u 07.10.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

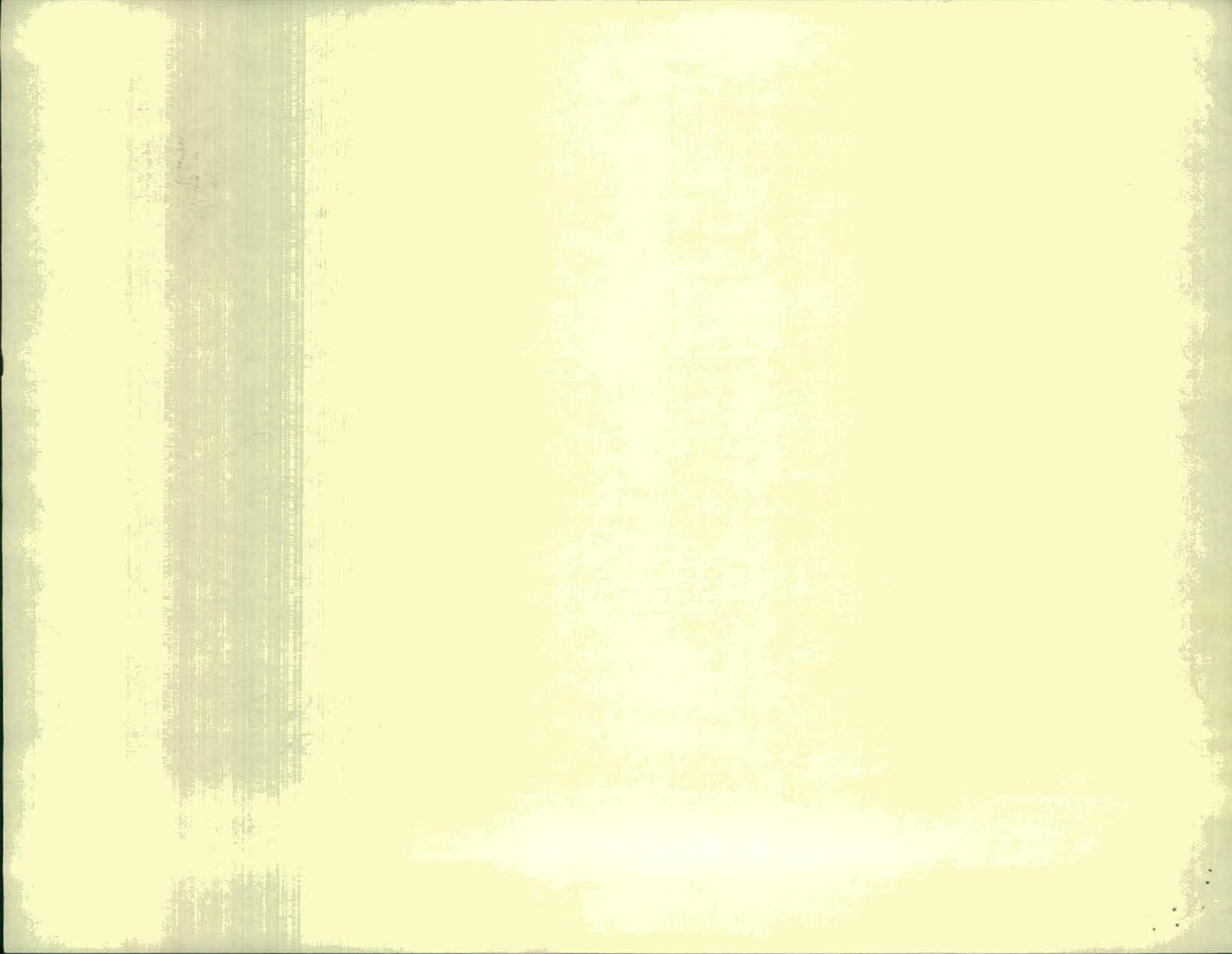
DART AEROSPACE LTD	Work Order:	34477
Description: Arm	Part Number:	D3560-4
Inspection Dwg: D3560 Rev: B		Page 1 of 1

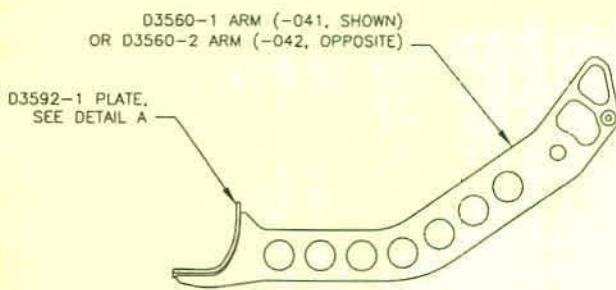
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

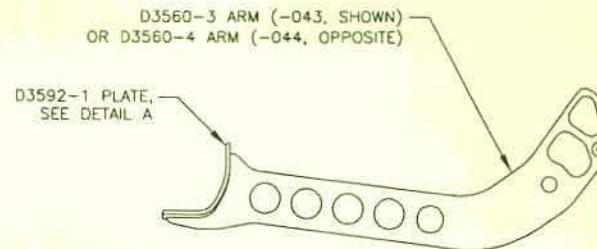
Measured by:	<i>J.F.</i>	Audited by:	<i>J.F.</i>	Prototype Approval:	N/A
Date:	07/09/22	Date:	07/09/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	Z

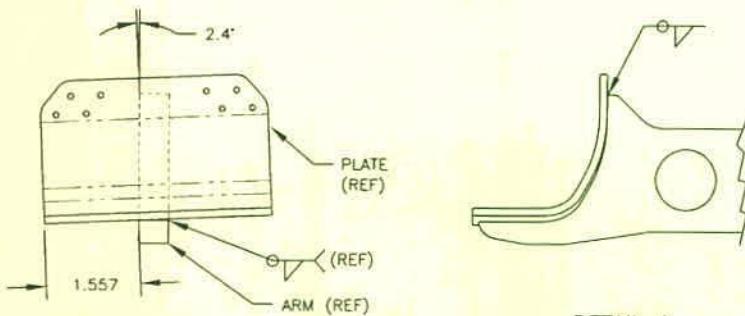




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

#### GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
[07.06.19]

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DESIGN	DRAWN BY	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
<b>DART</b> DART AEROSPACE LTD., HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO. REV. C D3560 SHEET 1 OF 3
DATE	07.06.19	TITLE SCALE ARM WELDMENT 1:1

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WITHOUT NOTICE  
WORK ORDER  
NO. 34477



7.65

PROFILE TO MATCH  
D3582-1 PLATE,  
MACHINE AT 2.4'  
SEE SECTION  
B-B

5.633

0.188 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

0.250  
0.275  
0.75  
C'BORE  $\phi 0.507^{+0.001}_{-0.001}$   
0.250 DEEP FROM  
THIS SIDE

4.481

B

R0.30

2.465

R0.30

0.000

R0.30

0.79

R0.30

1.37

R0.30

2.117

R0.30

2.86

R0.30

3.426

R0.30

4.801

R0.30

1.700

R0.30

2.000

R0.30

1.300

R0.30

0.850

R0.30

R0.35

(TYP)

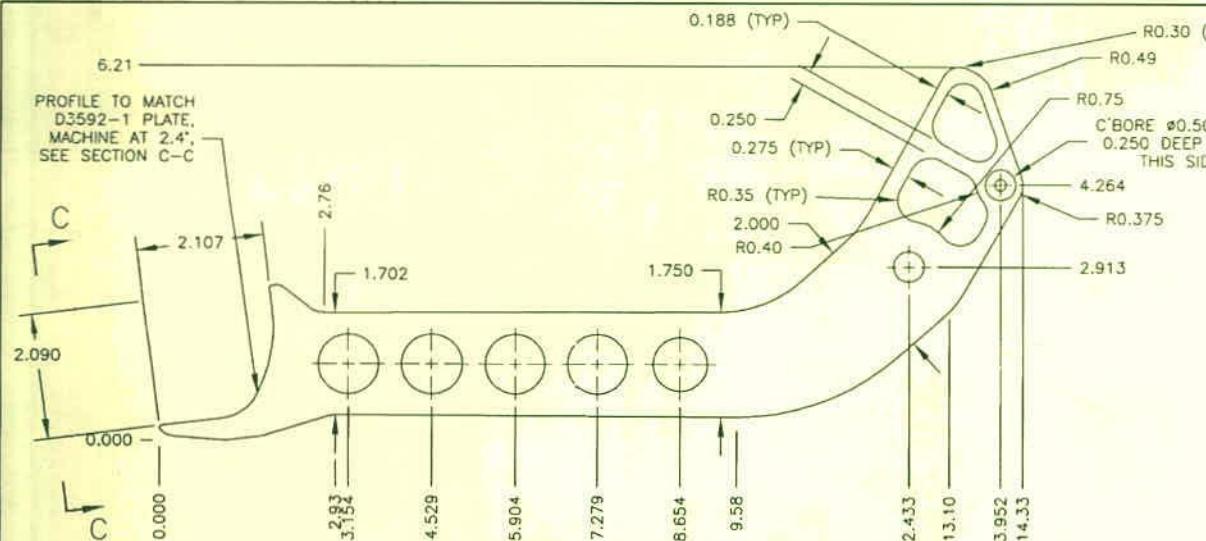
R0.40

R0.



6.21

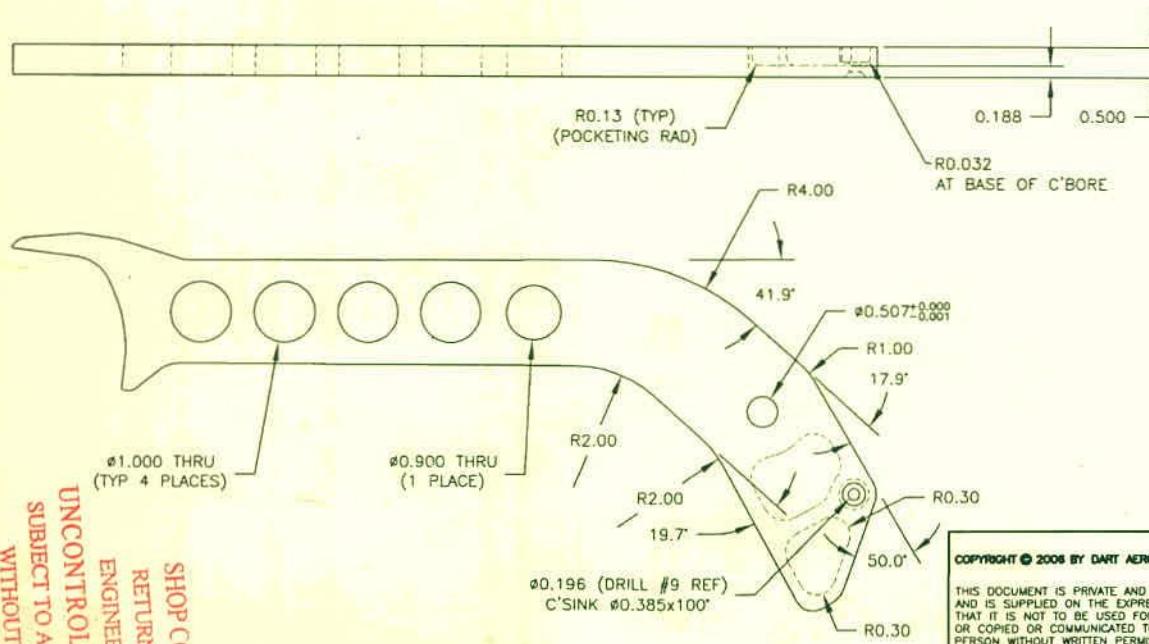
PROFILE TO MATCH  
D3592-1 PLATE,  
MACHINE AT 2.4",  
SEE SECTION C-C



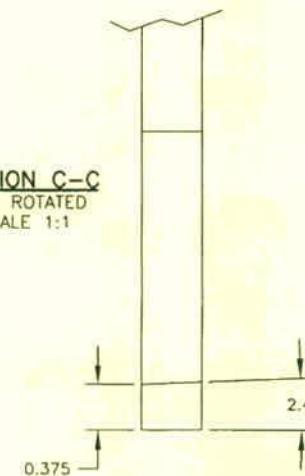
R0.30 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

### D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C  
VIEW ROTATED  
SCALE 1:1



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07.06.29

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED		REV. C DRAWING NO. D3560 SHEET 3 OF 3
DATE 07.06.19		TITLE ARM WELDMENT	SCALE 1:2

